

Work Order ID 99200A

99200A

Page 1

July-03-13 11:38:04 AM

Item ID: D117-837-011 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Utility-Basket, LH/RH
 Start Date: 7/03/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/05/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| IIN-D117-837 | A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP D117-837-011 CHG001 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 120 | QC4- 100% Inspect kits for completeness - labels | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

U 1307-11

13/2/14 DAS 06/1

Work Order ID 99200A

99200A

Page 2

July-03-13 11:38:04 AM

Item ID: D117-837-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Utility-Basket, LH/RH

Start Date: 7/03/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/05/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D117-837-011 Location: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

u 13.07.10

Picklist Print

July-03-13 11:38:04 AM

Page 1

Work Order ID: 99200A

Parent Item: D117-837-011

Parent Item Name: Heli-Utility-Basket, LH/RH

Start Date: 7/03/13

Required Date: 7/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.28 NEW ISSUE DD VERF:JLM
837 REV.A DD VERF:JFS

IPP REV:B 13.06.21 IIN-D117-

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D117-837-012 | | Manufactured | No | | | | Each | 1.0000 | | 1 | | | |
| HELI UTILITY BASKET, RH | | | | | | | | | | | | | |
| now -011- arc to reflect this | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | prelim | | 1 | | | | | | | |
| | | | | 99200 | | 1 | | | | | | | |
| D4784-011 | | Manufactured | No | | | | Each | 0.0000 | | | | | |
| Basket Assembly, Heavy Duty Lid, LH/RH | | | | | | | | | | | | | |
| D4794-1 | | Manufactured | No | | | | Each | 2.0000 | | | | | |
| Strut | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | prelim | | 1 | | | | | | | |
| | | | | 98833 | | 1 | | | | | | | |
| | | | | ST | | 1 | | | | | | | |
| | | | | 103339 | | 1 | | | | | | | |
| D4911-1 | | Manufactured | No | | | | Each | 2.0000 | | | | | |
| Bracket | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST124 | | 2 | | | | | | | |
| | | | | 103340 | | 2 | | | | | | | |
| D4911-3 | | Manufactured | No | | | | Each | 0.0000 | | | | | |
| Bracket | | | | | | | | | | | | | |

pulled to continue
parts as there
is no longer -012

103332

B103339

B103340

B103341

Linda Lacelle

From: David Shepherd
Sent: July-10-13 7:18 PM
To: Linda Lacelle; Marc Bellavance
Cc: Harvey Siemens; Nigel Forbes
Subject: RE: BK 117 basket

Should be CHG 001.

Regards,
David

From: Linda Lacelle
Sent: July-10-13 12:16 PM
To: David Shepherd; Marc Bellavance
Cc: Harvey Siemens; Nigel Forbes
Subject: RE: BK 117 basket

Thx...one other question I should have asked...CHG001 or 002?

From: David Shepherd
Sent: July-10-13 1:26 PM
To: Linda Lacelle; Marc Bellavance
Cc: Harvey Siemens; Nigel Forbes
Subject: RE: BK 117 basket

Sorry Linda ... You are correct ... The part number is D117-837-011.

Regards,
David

From: Linda Lacelle
Sent: July-10-13 11:22 AM
To: David Shepherd; Marc Bellavance
Cc: Harvey Siemens; Nigel Forbes
Subject: RE: BK 117 basket

Anyone pls?

From: Linda Lacelle
Sent: July-09-13 9:42 AM
To: David Shepherd; Marc Bellavance
Cc: Harvey Siemens; Kory Hagen; Nigel Forbes; Bill Beckett
Subject: RE: BK 117 basket

David, we would like to get this packaged, but I am just checking on the label- the red and white labels should read D117-837-011, correct?

LL

From: David Shepherd
Sent: July-04-13 5:56 PM
To: Linda Lacelle; Marc Bellavance
Cc: Harvey Siemens; Kory Hagen; Nigel Forbes; Bill Beckett
Subject: RE: BK 117 basket

Thanks for getting this done, Linda.

As discussed earlier this week, if they are flying with the prototype basket, they are flying illegally and I want to get them the rest of their parts ASAP.

Regards,
David

From: Linda Lacelle
Sent: July-04-13 3:05 PM
To: Marc Bellavance
Cc: Harvey Siemens; David Shepherd; Kory Hagen; Nigel Forbes; Bill Beckett
Subject: Re: BK 117 basket

The boys got it done. Will be in paint first thing tomorrow morning.

L

Sent from my iPhone

On 2013-07-03, at 2:06 PM, "Marc Bellavance" <mbellavance@dartaero.com> wrote:

Thanks Harvey, I will keep this one on standby up until you get back to me with the shipping info I need.

Marc

From: Harvey Siemens
Sent: Wednesday, July 03, 2013 1:54 PM
To: Marc Bellavance
Cc: David Shepherd; Linda Lacelle; Kory Hagen
Subject: RE: BK 117 basket

Marc,

Just talked with Marc B at Great Slave. The aircraft is moving in the next couple of days to a very undesirable place and he would prefer to hold shipment until they have established themselves at this place before shipping. This must be a "new" base of operations for them because he doesn't have anybody there to receive stuff or anything. He has promised me that as soon as he knows, he will let me know. That being said; as soon as I know, you will know.

Hope that helps, let me know if you need more info (that I can't provide)

Regards,

Harvey

From: Marc Bellavance
Sent: July-03-13 8:23 AM
To: Harvey Siemens
Cc: David Shepherd; Linda Lacelle; Kory Hagen
Subject: RE: BK 117 basket

Harvey,

Please contact Marc Bilodeau and provide me with a contact name and ship to address for the no charge PO.

Thanks,
Marc

From: Linda Lacelle
Sent: Wednesday, July 03, 2013 9:21 AM
To: Kory Hagen; Marc Bellavance
Cc: Harvey Siemens; David Shepherd
Subject: RE: BK 117 basket
Importance: High

We are aiming for Friday for the basket and the 3 other parts, can we pls have the N/C asap, so this doesn't happen at the last minute plssssssssssssssss

From: David Shepherd
Sent: June-28-13 12:38 AM
To: Linda Lacelle
Cc: Marc Bellavance; Linda Lacelle; Kory Hagen; Harvey Siemens
Subject: RE: BK 117 basket

Yup ... Sure did ... My understanding was that Great Slave was desperate for a basket to go on contract up North. They currently have a prototype basket. If they are flying the basket without the strut, then they are not flying in compliance with the STC. When will their basket be ready to ship?

Regards,
David

From: Linda Lacelle
Sent: June-27-13 2:39 PM
To: David Shepherd
Subject: Fwd: BK 117 basket

Sigh. I thought you wanted these parts out asap?

Sent from my iPhone

Begin forwarded message:

From: Kory Hagen <khagen@dartaero.com>
Date: 27 June, 2013 4:16:12 PM EDT
To: Marc Bilodeau <mbilodeau@gsheli.com>, Linda Lacelle <llacelle@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>, Marc Bellavance

<mbellavance@dartaero.com>

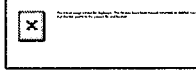
Subject: RE: BK 117 basket

Thanks Marc Will do
Here's your answer Linda

Kory Hagen

Sales Account Executive (Canada)

DART AEROSPACE



From: Marc Bilodeau [<mailto:mbilodeau@gsheli.com>]

Sent: Thursday, June 27, 2013 4:12 PM

To: Harvey Siemens; Marc Bellavance

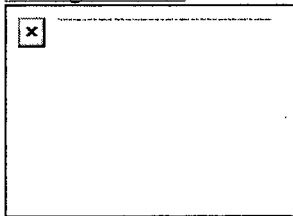
Cc: Kory Hagen

Subject: RE: BK 117 basket

Hi Guys, please hold everything until ready for one shipment. Once everything is ready please let me know and I will see where the aircraft is at that time.

Thanks

Marc Bilodeau
Production Manager
Great Slave Helicopters Ltd.
Ph: (403)286-2040
Cell: (403)809-8140
mbilodeau@gsheli.com
www.gsheli.com



From: Harvey Siemens [<mailto:hsiemens@dartaero.com>]

Sent: Thursday, June 27, 2013 1:59 PM

To: Marc Bellavance; Marc Bilodeau

Subject: RE: BK 117 basket

Marc Bellavance

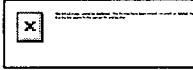
Just hold those parts to go with the basket. They are of no use without the new basket.

Let us know when the basket is ready to ship and Marc Bilodeau will let us know where the aircraft is.

Thanks

Regards,
Harvey Siemens
Lead Mechanical Designer

DART AEROSPACE
T 1 403 717-0328 > 402
M 1 403 512-4099
www.dartaerospace.com



From: Marc Bellavance
Sent: June-27-13 1:53 PM
To: Harvey Siemens; Marc Bilodeau
Subject: RE: BK 117 basket

Marc/Harvey,

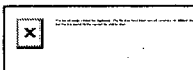
Correction: only the following parts of the BK117 basket are ready to ship: D4794-1, D4911-1/-3.

I believe that the basket will only be shipped sometimes in July.

Regards,

Marc Bellavance
Technical / Shop Support

DART AEROSPACE
T 1 613 632-5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



Technical Publications: Verify Revision Status/Download [HERE!](#)

From: Harvey Siemens
Sent: Thursday, June 27, 2013 3:49 PM
To: Marc Bilodeau
Cc: Marc Bellavance
Subject: BK 117 basket

Marc

The BK117 basket is ready to ship. Let me know where the aircraft is and I will have the basket shipped there direct from Hawkesbury.

The old basket can come back to me here in Calgary please.

Thanks for letting us know.

Regards,
Harvey Siemens

Linda Lacelle

From: Harvey Siemens
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Cc: David Shepherd; Linda Lacelle; Kory Hagen
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Subject: RE: BK 117 basket

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Yup ... Sure did ... My understanding was that Great Slave was desperate for a basket to go on contract up North. They currently have a prototype basket. If they are flying the basket without the strut, then they are not flying in compliance with the STC. When will their basket be ready to ship?

Regards,
David

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To: David Shepherd
Subject: Fwd: BK 117 basket

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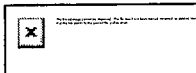
Sent from my iPhone

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Thanks Marc Will do
Here's your answer Linda

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Sales Account Executive (Canada)
DART AEROSPACE



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Thanks

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Production Manager
Great Slave Helicopters Ltd.
Ph: (403)286-2040
Cell: (403)809-8140
mbilodeau@gsheli.com
www.gsheli.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

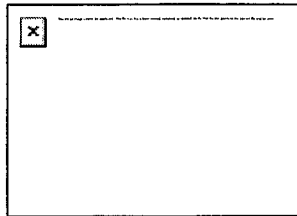
Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|



From: Harvey Siemens [<mailto:hsiemens@dartaero.com>]

Sent: Thursday, June 27, 2013 1:59 PM

To: Marc Bellavance; Marc Bilodeau

Subject: RE: BK 117 basket

Marc Bellavance

Just hold those parts to go with the basket. They are of no use without the new basket.

Let us know when the basket is ready to ship and Marc Bilodeau will let us know where the aircraft is.

Thanks

Regards,

Harvey Siemens

Lead Mechanical Designer

DART AEROSPACE

T 1 403 717-0328 > 402

M 1 403 512-4099

www.dartaerospace.com



From: Marc Bellavance

Sent: June-27-13 1:53 PM

To: Harvey Siemens; Marc Bilodeau

Subject: RE: BK 117 basket

Marc/Harvey,

Correction: only the following parts of the BK117 basket are ready to ship: D4794-1, D4911-1/-3.

I believe that the basket will only be shipped sometimes in July.

Regards,

Marc Bellavance

Technical / Shop Support

DART AEROSPACE

T 1 613 632-5200 > 243

M 1 613 676 0992

F 1 613 632 9311

S marcbellavance

www.dartaerospace.com



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Technical Publications: Verify Revision Status/Download [HERE!](#)

From: Harvey Siemens
Sent: Thursday, June 27, 2013 3:49 PM
To: Marc Bilodeau
Cc: Marc Bellavance
Subject: BK 117 basket

Marc

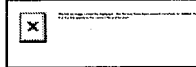
The BK117 basket is ready to ship. Let me know where the aircraft is and I will have the basket shipped there direct from Hawkesbury.

The old basket can come back to me here in Calgary please.

Thanks for letting us know.

Regards,
Harvey Siemens
Lead Mechanical Designer

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Linda Lacelle

From: David Shepherd
Sent: June-24-13 2:26 PM
To: Linda Lacelle; Mike Petsche; Sian Willems
Cc: Kim Johnston
Subject: RE: D117-837 Basket (ECN 13-578)

Linda,

We need to get them the strut (D4794-1) and two brackets (D4911-1/-3) right away. They can probably wait a couple weeks for the basket itself.

Regards,
David

From: Linda Lacelle
Sent: June-24-13 8:45 AM
To: Mike Petsche; Sian Willems
Cc: David Shepherd; Kim Johnston
Subject: RE: D117-837 Basket (ECN 13-578)

And when do they expect these parts? Because of the mess with the 205 baskets for PHI, we won't be able to do this for another 2 wks approx
LL

From: Linda Lacelle
Sent: June-21-13 1:18 PM
To: Kim Johnston; Sian Willems; Mike Petsche
Cc: David Shepherd
Subject: FW: D117-837 Basket (ECN 13-578)

Kim, have you given a copy of this to Sian?
The comment to ship to Great Slaves asap...I believe this is a n/C ? and when they receive the mentioned parts on the ecn, we can then ship the D117-837-011 out of the system? Am I correct here?
LL

From: David Duval
Sent: June-21-13 12:38 PM
To: Linda Lacelle
Subject: RE: D117-837 Basket (ECN 13-578)

Done.....
But for the w/o's that are in the shop.
All w/o's with those part number all changed.
All old w/o's (ROUTES/BOMS) in the shop should they be remove and reprint with updated versions
The IIN's had a lot of changes to be done.

Thanks.

David Duval

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Linda Lacelle

From: David Shepherd
Sent: June-28-13 12:38 AM
To: Linda Lacelle
Cc: Marc Bellavance; Linda Lacelle; Kory Hagen; Harvey Siemens
Subject: RE: BK 117 basket

Yup ... Sure did ... My understanding was that Great Slave was desperate for a basket to go on contract up North. They currently have a prototype basket. If they are flying the basket without the strut, then they are not flying in compliance with the STC. When will their basket be ready to ship?

Regards,
David

From: Linda Lacelle
Sent: June-27-13 2:39 PM
To: David Shepherd
Subject: Fwd: BK 117 basket

Sigh. I thought you wanted these parts out asap?

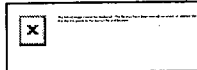
Sent from my iPhone

Begin forwarded message:

From: Kory Hagen <khagen@dartaero.com>
Date: 27 June, 2013 4:16:12 PM EDT
To: Marc Bilodeau <mbilodeau@gsheli.com>, Linda Lacelle <llacelle@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>, Marc Bellavance <mbellavance@dartaero.com>
Subject: RE: BK 117 basket

Thanks Marc Will do
Here's your answer Linda

Kory Hagen
Sales Account Executive (Canada)
DART AEROSPACE

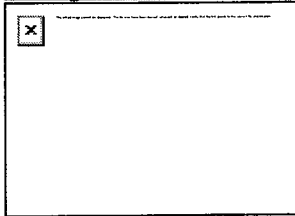


From: Marc Bilodeau [<mailto:mbilodeau@gsheli.com>]
Sent: Thursday, June 27, 2013 4:12 PM
To: Harvey Siemens; Marc Bellavance
Cc: Kory Hagen
Subject: RE: BK 117 basket

Hi Guys, please hold everything until ready for one shipment. Once everything is ready please let me know and I will see where the aircraft is at that time.

Thanks

Marc Bilodeau
Production Manager
Great Slave Helicopters Ltd.
Ph: (403)286-2040
Cell: (403)809-8140
mbilodeau@gsheli.com
www.gsheli.com



From: Harvey Siemens [<mailto:hsiemens@dartaero.com>]
Sent: Thursday, June 27, 2013 1:59 PM
To: Marc Bellavance; Marc Bilodeau
Subject: RE: BK 117 basket

Marc Bellavance

Just hold those parts to go with the basket. They are of no use without the new basket.

Let us know when the basket is ready to ship and Marc Bilodeau will let us know where the aircraft is.

Thanks

Regards,
Harvey Siemens
Lead Mechanical Designer

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M 1 403 512-4099
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From: Marc Bellavance
Sent: June-27-13 1:53 PM
To: Harvey Siemens; Marc Bilodeau
Subject: RE: BK 117 basket

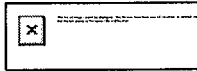
Marc/Harvey,

Correction: only the following parts of the BK117 basket are ready to ship: D4794-1, D4911-1/-3.
I believe that the basket will only be shipped sometimes in July.

Regards,

Marc Bellavance
Technical / Shop Support

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M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



Technical Publications: Verify Revision Status/Download [HERE!](#)

From: Harvey Siemens
Sent: Thursday, June 27, 2013 3:49 PM
To: Marc Bilodeau
Cc: Marc Bellavance
Subject: BK 117 basket

Marc

The BK117 basket is ready to ship. Let me know where the aircraft is and I will have the basket shipped there direct from Hawkesbury.

The old basket can come back to me here in Calgary please.

Thanks for letting us know.

Regards,
Harvey Siemens
Lead Mechanical Designer

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M 1 403 512-4099
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Work Order ID 99200

April-01-13 10:32:44 AM

Slip IMMEDIATELY!
AAP

99200

PRELIMINARY ISSUE

FOR TESTING TO CALGARY Page 1

Item ID: D117-837-012

Accept

N9000040100

Setup Start *NS1*

Revision ID: PRELIM

Item Name: Quick Release Heli-Utility-Basket. RH

Stop *NS2*

Start Date: 4/01/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/15/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-04-01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

IIN-D117-837

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-837-012 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

[Handwritten signature]
[Handwritten signature]
[Handwritten signature] ①

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | |
|--------------------------|------------------------------|--------------------------|----------------|--------------------------|---------------------------------|--------------------------|----------------------|--------------------------|--------------------|-----------------|--|
| Landing Gear | | | General | | | Grain | | Ovalized | | Pressure/Forced | |
| <input type="checkbox"/> | Bending | <input type="checkbox"/> | Bend | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Ovalized | <input type="checkbox"/> | Pressure/Forced | | |
| <input type="checkbox"/> | Centre Not Concentric to O/S | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Temperature/Cure | | |
| <input type="checkbox"/> | Cracks | <input type="checkbox"/> | Broken/Damaged | <input type="checkbox"/> | Inspection Incomplete | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Weld | | |
| <input type="checkbox"/> | Crushed/Crimped | <input type="checkbox"/> | Burrs | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Wrong Stock Pulled | | |
| <input type="checkbox"/> | Cuffs | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Maintenance | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | | | |
| <input type="checkbox"/> | Heat Treat | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | Other | | |
| <input type="checkbox"/> | Inspection Strip in Tube | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Power Loss/Surge | | | | |
| <input type="checkbox"/> | Ripples in Bend | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Offset | | | | | | |
| <input type="checkbox"/> | Torque Waves in Extrusion | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Out of Calibration | | | | | | |
| <input type="checkbox"/> | Turning Sequence | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Out of Sequence | | | | | | |
| <input type="checkbox"/> | Wave/Twist in Tube | <input type="checkbox"/> | Folio | <input type="checkbox"/> | Outside Dimensions | | | | | | |

Work Order ID 99200

April-01-13 10:32:44 AM

99200

Page 2

Item ID: D117-837-012

Accept

N9000040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Quick Release Heli-Utility-Basket. RH

Start Date: 4/01/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/15/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 | | 0.00 | | | | | | | |
| *130* | Packaging | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D117-837-012 Location: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

POSITIVE RECALL

EFFECTIVE 130408 AUTH u

RELEASED _____ DATE _____

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | |
|---|---|--|---|---|--|-------|--|-------|--|
| Landing Gear | | | General | | | Grain | | Other | |
| <input type="checkbox"/> Bending | <input type="checkbox"/> Bend | <input type="checkbox"/> Grain | <input type="checkbox"/> Ovalized | <input type="checkbox"/> Pressure/Forced | | | | | |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> BOM/Route | <input type="checkbox"/> Hardware | <input type="checkbox"/> Over/Under tolerance | <input type="checkbox"/> Temperature/Cure | | | | | |
| <input type="checkbox"/> Cracks | <input type="checkbox"/> Broken/Damaged | <input type="checkbox"/> Inspection Incomplete | <input type="checkbox"/> Part Incorrect | <input type="checkbox"/> Weld | | | | | |
| <input type="checkbox"/> Crushed/Crimped | <input type="checkbox"/> Burrs | <input type="checkbox"/> Instructions Incomplete/Unclear | <input type="checkbox"/> Part Lost/Missing | <input type="checkbox"/> Wrong Stock Pulled | | | | | |
| <input type="checkbox"/> Cuffs | <input type="checkbox"/> Contamination | <input type="checkbox"/> Maintenance | <input type="checkbox"/> Part Moved | | | | | | |
| <input type="checkbox"/> Heat Treat | <input type="checkbox"/> Countersink | <input type="checkbox"/> Mislabeled | <input type="checkbox"/> Positioned Wrong | | | | | | |
| <input type="checkbox"/> Inspection Strip in Tube | <input type="checkbox"/> Cut Too Short | <input type="checkbox"/> Misread | <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Other | | | | | |
| <input type="checkbox"/> Ripples in Bend | <input type="checkbox"/> Drill Holes | <input type="checkbox"/> Offset | | | | | | | |
| <input type="checkbox"/> Torque Waves in Extrusion | <input type="checkbox"/> Drawing | <input type="checkbox"/> Out of Calibration | | | | | | | |
| <input type="checkbox"/> Turning Sequence | <input type="checkbox"/> Finish | <input type="checkbox"/> Out of Sequence | | | | | | | |
| <input type="checkbox"/> Wave/Twist in Tube | <input type="checkbox"/> Folio | <input type="checkbox"/> Outside Dimensions | | | | | | | |

Picklist Print

April-01-13 10:32:48 AM

Page 1

Work Order ID: 99200

992000

Parent Item: D117-837-012

D117-837-012

Parent Item Name: Quick Release Heli-Utility-Basket. RH

Start Date: 4/01/13

Required Date: 4/15/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.28 NEW ISSUE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D117-837-112 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 99210 | R |
| *D117-837-112* | | | | | | | | | ** | | | | |
| Quick Release Basket Mounting Installation, RH | | | | | | | | | | | | | |
| D4784-011 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 98834 | |
| *D4784-011* | | | | | | | | | ** | | | | |
| Basket Assembly, Heavy Duty Lid, LH/RH | | | | | | | | | | | | | |
| D4787-041 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 99075 | |
| *D4787-041* | | | | | | | | | ** | | | | |
| Fwd Bracket Assembly | | | | | | | | | | | | | |
| D4788-041 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 99080 | |
| *D4788-041* | | | | | | | | | ** | | | | |
| Aft Bracket Assembly | | | | | | | | | | | | | |
| D4789-5 | | Manufactured | No | | | | Each | 0.0000 | | 8 | | | |
| *D4789-5* | | | | | | | | | ** | | | | |
| Bushing | | | | | | | | | | | | | |
| D4794-1 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 98833 | R |
| *D4794-1* | | | | | | | | | ** | | | | |
| Strut | | | | | | | | | | | | | |
| D4795-1 | | Manufactured | No | | | | Each | 0.0000 | | 1 | | 98831 | R |
| *D4795-1* | | | | | | | | | ** | | | | |
| Bracket | | | | | | | | | | | | | |
| AN3C13A | | Purchased | No | | | | Each | 37.0000 | | 2 | | | |
| *AN3C13A* | | | | | | | | | ** | | | | |
| Bolt | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

ST351

37

122639

37

122639

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|---|-------------|-------------|------------|---|--------------------------|---|------------------------|---------------------|---------------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | |
|---|---|---|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

April-01-13 10:32:48 AM

Page 2

Work Order ID: 99200

Parent Item: D117-837-012

Parent Item Name: Quick Release Heli-Utility-Basket. RH

99200

D117-837-012

Start Date: 4/01/13

Required Date: 4/15/13

Start Qty: 1.00

Required Qty: 1.00

AN4-21A
AN4-21A
Bolt

Purchased No

Each 55.0000 4

**

Location

Loc Qty

Loc Code

ST358

5

122416

5

ST515

50

124858

50

Purchased No

Each 2,998.000

**

MS21042L4
MS21042L4
Nut

Location

Loc Qty

Loc Code

FP001

318

122452

306

8182

12

FP-001

12

8182

12

GA

34

121444

34

ST314

76

116548

4

119017

20

123248

36

123355

16

ST518

2558

124231

2558

mb2416

4

124231

April-01-13 10:32:48 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
|--|------|------|-----|---|-------------------|---|-------------|--------------|--------------|--|--|
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | | | |

| FAULT CATEGORY | | | | | | | | | | | |
|---|--|--|---|--|--|---|--|--|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

Picklist Print

April-01-13 10:32:48 AM

Page 3

Work Order ID: 99200

Parent Item: D117-837-012

Parent Item Name: Quick Release Heli-Utility-Basket. RH

99200

D117-837-012

Start Date: 4/01/13

Required Date: 4/15/13

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

Each

2.688.000

4

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

80

103691

80

GA

106

123899

106

ST315

2502

123899

196

124555

2306

Each

7,903.000

**

NAS1149C0332R

Purchased

No

NAS1149C0332R

Washer

Location

Loc Qty

Loc Code

FP001

264

123355

264

ST292

2997

123248

18

123759

2979

ST517

4642

124580

4642

Each

918.0000

**

NAS1149F0432P

Purchased

No

NAS1149F0432P

Washer

Location

Loc Qty

Loc Code

ST295

918

122151

2

123522

4

123900

212

124580

400

124859

300

April-01-13 10:32:49 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| | | | | | | | | | | | |
|--|------|------|-----|---|----------------------|---|----------------|--------------|--------------|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |

| FAULT CATEGORY | | | |
|---|---|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

REFERENCE ONLY**5.0 PARTS LIST**

| Qty -011 | Qty -012 | Qty -111 | Qty -112 | Part Number | Description |
|-------------|-------------|-------------|-------------|------------------------|---------------------------------------|
| X | | | | D117-837-011 | QUICK RELEASE HELI-UTILITY-BASKET, LH |
| | X | | | D117-837-012 | QUICK RELEASE HELI-UTILITY-BASKET, RH |
| 1 | | X | | D117-837-111 | QUICK RELEASE BASKET MOUNTING KIT, LH |
| | 1 | | X | D117-837-112 | QUICK RELEASE BASKET MOUNTING KIT, RH |
| 1* | 1* | | | D2332-041 | PROP ASSEMBLY (OPTIONAL) |
| 4* | 4* | | | D3953-9 | WASHER |
| 1 | 1 | | | D4784-011 | BASKET ASSEMBLY, HEAVY DUTY, LH/RH |
| 1 | 1 | | | D4787-041 | FWD BRACKET ASSEMBLY |
| 1 | 1 | | | D4788-041 | FWD BRACKET ASSEMBLY |
| | | 2 | 2 | D4789-1 | CLEVIS |
| | | 2 | 2 | D4789-3 | CLEVIS |
| 8 | 8 | | | D4789-5 | BUSHING |
| | | 1 | 1 | D4790-041 | FWD CHANNEL ASSEMBLY |
| | | 1 | 1 | D4790-043 | FWD CHANNEL ASSEMBLY |
| | | 1 | | D4791-041 | AFT CHANNEL ASSEMBLY |
| | | | 1 | D4791-042 | AFT CHANNEL ASSEMBLY |
| | | 1 | 1 | D4791-043 | AFT CHANNEL ASSEMBLY |
| | | 8 | 8 | D4792-1 | ANGLE |
| | | 1 | 1 | D4792-3 | ANGLE |
| | | 1 | 1 | D4792-4 | ANGLE |
| | | 1 | 1 | D4792-5 | ANGLE |
| | | 1 | 1 | D4792-6 | ANGLE |
| | | 2 | 2 | D4792-7 | ANGLE |
| | | 2 | 2 | D4792-8 | ANGLE |
| 1 | 1 | | | D4794-1 | STRUT |
| 1 | 1 | | | D4795-1 | BRACKET |
| | | 1 | 1 | D4795-3 | BRACKET |
| | | 2 | 2 | AN3C7A | BOLT |
| 2 | 2 | | | AN3C13A | BOLT |
| | | 24 | 24 | AN4-6A | BOLT |
| 4 | 4 | | | AN4-21A | BOLT |
| 4 | 4 | | | MS21042L4 | NUT |
| 4 | 4 | | | MS21043-3 | NUT |
| | | 2 | 2 | MS21069L3 | ANCHOR NUT |
| | | 24 | 24 | MS21075L4 | ANCHOR NUT |
| | | 2 | 2 | MS27039-1-07 | SCREW |
| | | 4 | 4 | NAS1097AD3-(2) or (-3) | RIVET (this will pick up from Eagle) |
| 8 | 8 | 8 | 8 | NAS1149C0332R | WASHER (or AN960C10) |
| 3* | 3* | | | NAS1149C0463R | WASHER |
| | | 24 | 24 | NAS1149D0416J | WASHER (or AN960JD416L) |
| | | 2 | 2 | NAS1149F0332P | WASHER (or AN960-10L) |
| 4 | 4 | | | NAS1149F0432P | WASHER (or AN960-416L) |

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3989-3 GAS PRING

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Revision: A
Date: 13.02.08